

Work Order ID 83370

May-31-12 12:30:36 PM

Duplicate

83370

Page 1

Item ID: D3405-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Lug Assembly

Stop *NS2*

Start Date: 17/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: *MC*

Date: *12/05/31*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3405	Rev B

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

16 0 Jm 12-4-18

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

16 0 Jm 12-4-18

120		0.00							
-----	--	------	--	--	--	--	--	--	--

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/2/19

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83370

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N900040100

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Start Date: 17/04/2012 Start Qty: 16.00

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Brake NC	Memo	0.00				16			8/2/04/23
Brake NC	1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00				46			
Quality Control									
150		0.00							
150	Large Fab								
Large Fab	Memo	0.00				16			12-5-31
Large Fab	Weld as per Dwg D3405 use DT8484 Identify as D3405-041								

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC9- Inspect visual per QS1004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

180

White Gloss(Ref:4.3.5.2) per QS1005 4.3-Steel

0.00

180

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
8:30
400 OF

46

16X

12/06/04

m12/134

W/O:		WORK ORDER CHANGES						
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NR1

QC:

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SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				16	0	12-6-4	
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>51478</u> Memo	0.00 0.00				16		See 12/06/05	
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/6/598	

mf
12-06-05

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Picklist Print

May-31-12 12:30:41 PM

Page 1

Work Order ID: 83370

83370

Parent Item: D3405-041

D3405-041

Parent Item Name: Lug Assembly

Start Date: 17/04/2012

Required Date: 24/04/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP A05.09.01New issueKJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	59.0000	1	16			

D3404-1

GHW Lug

**

12-5-31

Location

Loc Qty

Loc Code

WA

59

83879

58

83983

1

M304S11GA

Purchased

No

150

sf

117.2200

0.154

2.593684

**

M304S11GA

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

117.22

121380

29.9

121780

87.32

121380

Jm
12-4-18

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

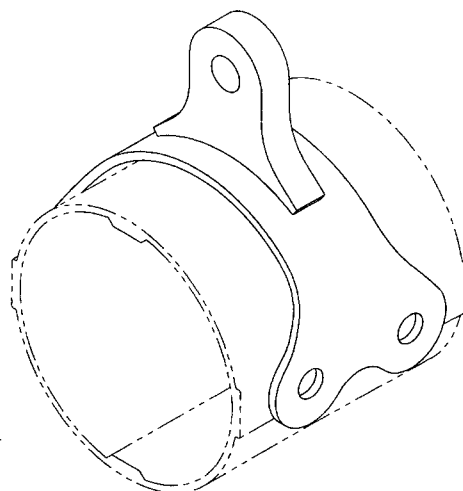
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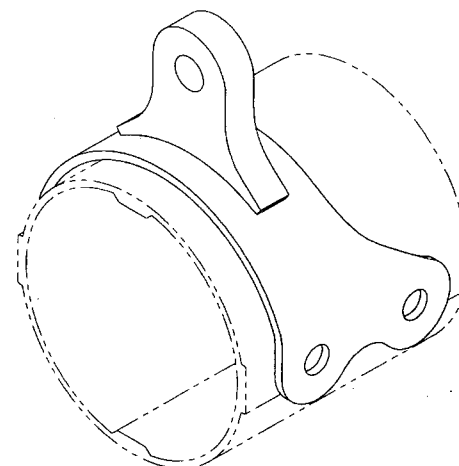
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 03370 MLS
n/asp



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)





D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18 MJS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

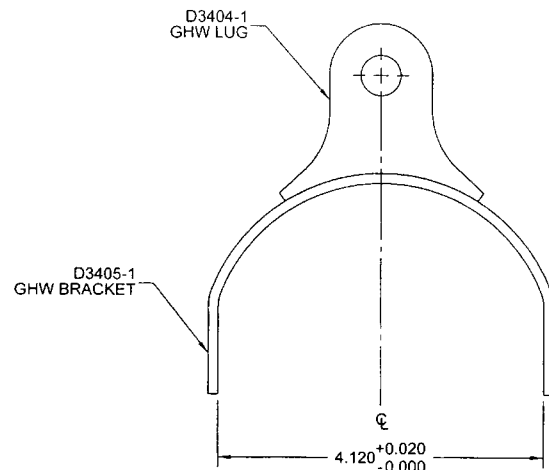
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

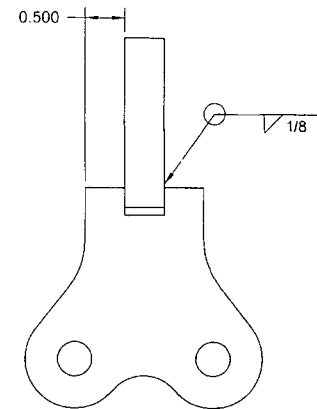
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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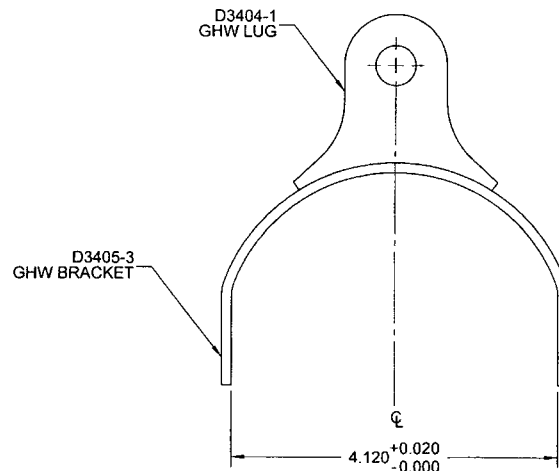
NOTE: Date & initial all entries



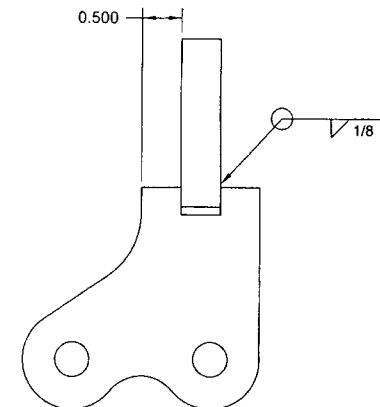
D3405-041 LUG ASSEMBLY



83370



D3405-043 LUG ASSEMBLY



RELEASED
06/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.		TITLE GHW LUG ASSEMBLY	SHEET 2 OF 4
APPROVED		SCALE	NTS
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DATE	08.09.19		

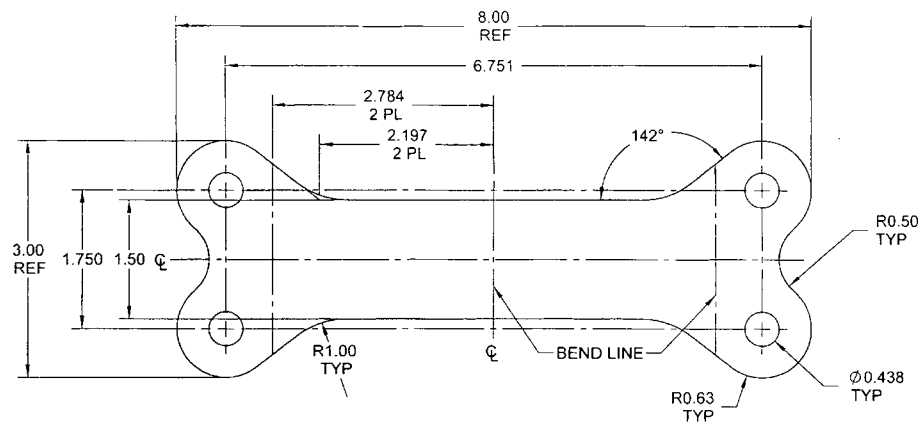
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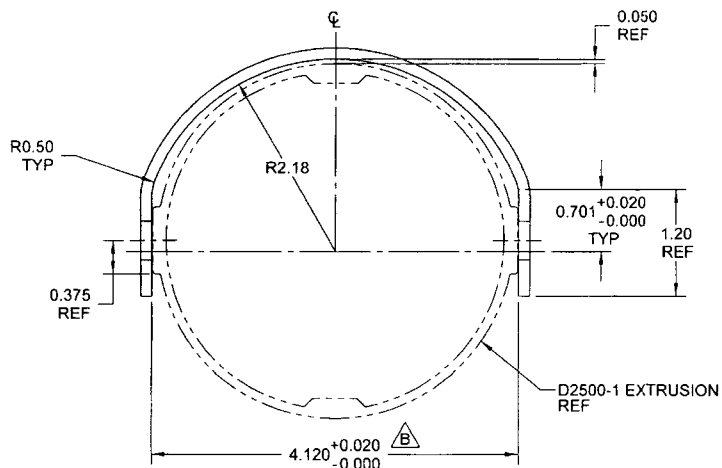
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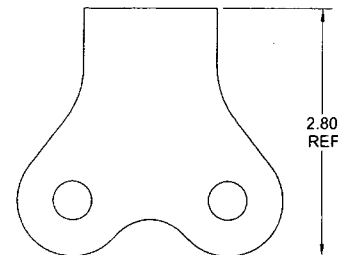
NOTE: Date & initial all entries



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

RELEASED
08/08/12/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE GHW LUG ASSEMBLY	SCALE NTS
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DATE	08.09.19		

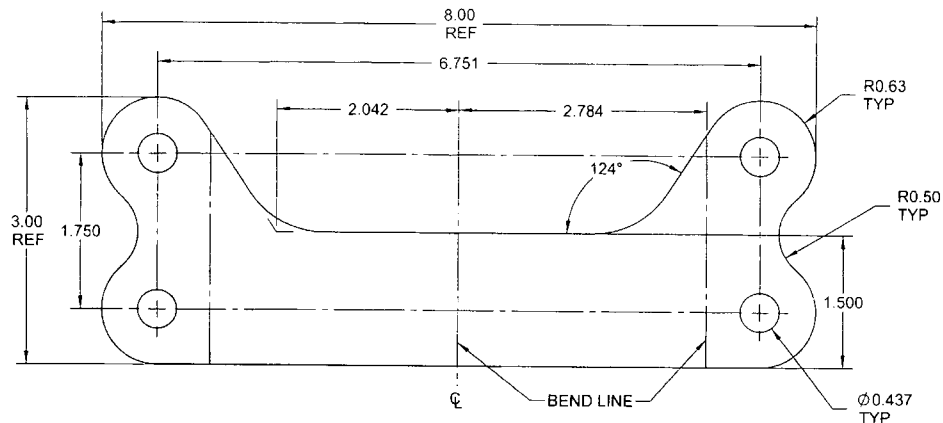
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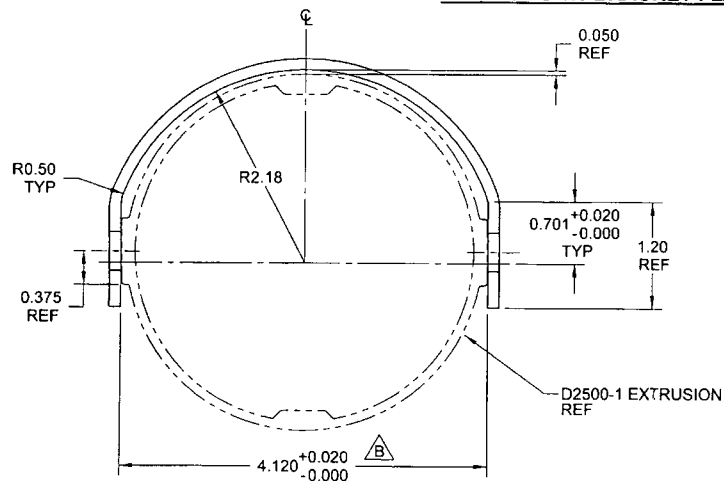
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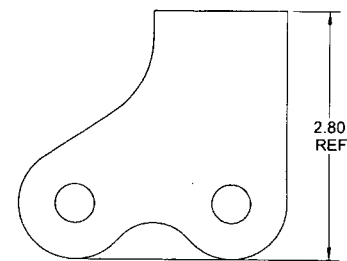
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D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)





SIDE VIEW FOR REF ONLY

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REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
08/12/18

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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APPROVED		TITLE	SCALE
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